

Work Order ID 69465

Wednesday, May 11, 2011 11:44:57 AM



Page 1

Item ID: D212-580-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Mirror Assembly

Start Date: 5/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 2.00



Customer:

Reference:



Approvals: Process Plan: *AK* Date: 11-05-11 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2161	B2								
IIN-D212-580-1	A								
100	DOCUMENT CONTROL	0.00							
									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D212-580-041 CHG004								
									<i>8/8/11/19</i>
160	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									

AK Cor BG 11-5-17
②

SB *AK* 11/05/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69465

Page 2

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Item ID: D212-580-041

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Start Date: 5/11/2011 Start Qty: 2.00



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Required Date: 5/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/11

72

Quality Control

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212--580
041 □ Location: _____ □ PPP Rev: _____

P44/0002

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24

MF

11-05-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 11:45:03 AM

Page 1

Work Order ID: 69465

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly



Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM
 IPP REV:I AS PER ECN10-611 10-09-07 JLM VERIFIED
 BY:DD IPP rev:J
 10.11.22 AS PER ECN10-642 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S ₄₂ D3439-101 Mirror Assembly 8"		Manufactured	No			100	Each	19.0000	2	4	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST226				19					
				62949				19		62949			
S ₅ D2161-212 Mirror Bracket, 212		Manufactured	No			100	Each	0.0000	1	2	✓		
										67730			
S ₁₂ MS20426AD3-4 RIVET		Purchased	No			100	Each	5,258.000	8	16	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				5258					
				104374				1258		104374			
				110398				4000					
S ₇₂ D4164-041 Nut Plate Adapter Assembly		Manufactured	No			100	Each	9.0000	4	8	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST135				9					
				65082				9		65082			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, May 11, 2011 11:45:04 AM

Work Order ID: 69465

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly



Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-08

Purchased

No

100

Each

1,046.000

4

8



Screw



JB 11/05/18

Location

Loc Qty

Loc Code

FP-A

107

110835

107

ST291

939

115108

639

117423

300

115108

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

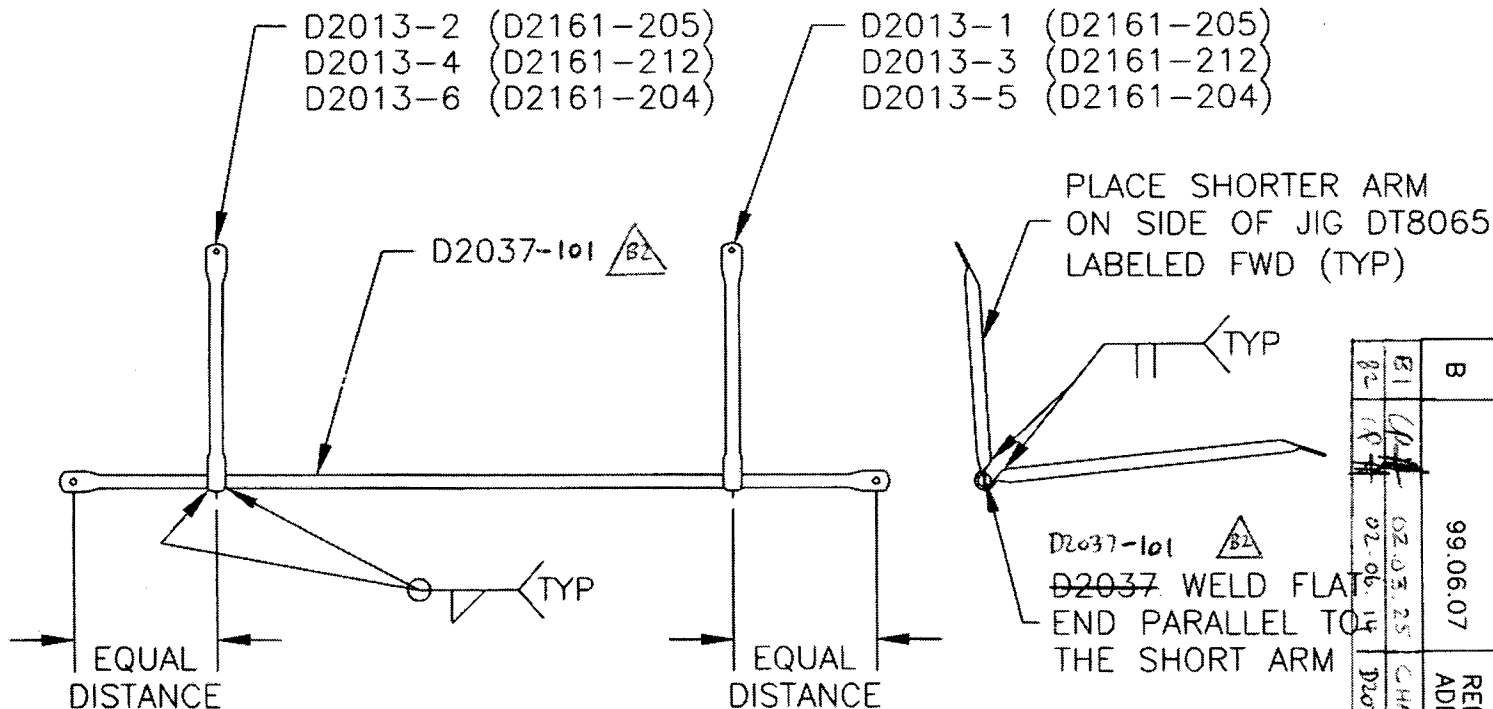
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69465

P11-05-4

DART

ISSUED



DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>KE</i>	<i>RT</i>	D2161
DATE	TITLE	SHEET 1 OF 1
99.06.07	MIRROR BRACKET	SCALE
		NTS
A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 WELD

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 *(B1)*

RELEASED
KE 49.06.10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 PARTS LIST

REFERENCE ONLY
5

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

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Revision: A
Date: 10.07.20